



Dart Aerospace Ltd.
1270 Aberdeen St
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K6A 1K7
Canada

Tel (613) 632-5200
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D350-591-121
Job Sheet 196994-A

Part No: D350-591-121

Job Qty: 1 pcs

Part Name: Heli-Access-Step™ LH - High Gear, Short Step, Float Compatible



Part Weight: 0 lbs

Status: Scheduled

Priority: Medium

Job Created: 7/24/19

Job Tracking No:

Due Date: 7/30/19

Created By: Linda Lacelle

Type: Stock

Description:

Note: DWG IIN-D350-591 REV H, D2351-041 REV E IPP Rev:E 02.10.21 Re-format; Incorporated D2351-041 IPP KJ/RF IPP rev. F 06.02.23 added grinding EC

Ship Via:

Bill of Materials

Job Routing

Op No	Operation	Qty	Start Date	Due Date	Standard		Workcenter/Supplier		Sign-off
					Setup Hrs	Run Hrs	Workcenter / Supplier	Lead Time	
170	Handfinish - 1-1 Chemical-B4B	1 pcs	7/30/19	7/30/19	0.00	0.19	Handfinish - 1 - 1 - B4B		SEP 12 2019
							Handfinish - 1 - 2 - B4B		
							Handfinish - 1 - 3 - B4B		
							Handfinish - 1 - 4 - B4B		
							Handfinish - 1 - 5 - B4B		
							Handfinish - 1 - 6 - B4B		
							Handfinish - 1 - 7 - B4B		
							Handfinish - 1 - 8 - B4B		
							Handfinish - 1 - 9 - B4B		
							Handfinish - 1 - 10 - B4B		
							Handfinish - 1 - 11 - B4B		
							Handfinish - 1 - 12 - B4B		
							Handfinish - 1 - 13 - B4B		
							Handfinish - 1 - 14 - B4B		
							Handfinish - 1 - 15 - B4B		
							Handfinish - 1 - 16 - B4B		
							Handfinish - 1 - 17 - B4B		
							Handfinish - 1 - 18 - B4B		
							Handfinish - 1 - 19 - B4B		
							Handfinish - 1 - 20 - B4B		
							Handfinish - 1 - 21 - B4B		
							Handfinish - 1 - 22 - B4B		
180	QC 7	1 pcs	7/30/19	7/30/19	0.00	0.00	QC 7 - 10		
							QC 7 - 13		
							QC 7 - 14		
							QC 7 - 15		
							QC 7 - 17		
							QC 7 - 18		
							QC 7 - 19		
							QC 7 - 2		



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CANADA
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Container No: S200086



Part: D350-591-121

Job No: 196994-A

Serial No/Batch: S196679

Revision: I, E

Inspector:

Exp Date:

Instructions: TC STC SH92-6 Issue 1d FAA STC SH967NE

					QC 7 - 28	
					QC 7 - 3	
					QC 7 - 30	
					QC 7 - 34	
					QC 7 - 36	
					QC 7 - 37	
					QC 7 - 41	
					QC 7 - 47	
					QC 7 - 48	
					QC 7 - 51	
					QC 7 - 58	
					QC 7 - 59	DAS
					QC 7 - 60	24
					QC 7 - 9	9-89
					QC 7 - 68	SEP 1 2 2019
					QC 7 - 50	
					QC 7 - 67	
					QC 7 - 40	
					QC 7 - 24	
					QC 7 - 43	
					QC 7 - 61	
					QC 7 - 81	
190	Large Fab - Steps - 3 - B4B	1	7/30/19	0.00 0.68	Large Fab - 1 - B4B	
	pcs				Large Fab - 10 - B4B	
					Large Fab - 2 - B4B	
					Large Fab - 3 - B4B	
					Large Fab - 4 - B4B	DAS
					Large Fab - 5 - B4B	24
					Large Fab - 6 - B4B	9-89
					Large Fab - 7 - B4B	SEP 1 2 2019
					Large Fab - 8 - B4B	
					Large Fab - 9 - B4B	
					Large Fab - 11 - B4B (Various)	
220	QC 10	1	7/30/19	0.00 0.00	QC 10 - 10	
	pcs				QC 10 - 18	
					QC 10 - 24	DAS
					QC 10 - 43	43
					QC 10 - 50	9-89
					QC 10 - 58	
					QC 10 - 9	
230	QC 5	1	7/30/19	0.00 0.00	QC 5 - 10	
	pcs				QC 5 - 12	
					QC 5 - 17	
					QC 5 - 18	
					QC 5 - 19	
					QC 5 - 22	
					QC 5 - 24	
					QC 5 - 3	
					QC 5 - 43	
					QC 5 - 49	
					QC 5 - 51	
					QC 5 - 58	
					QC 5 - 68	
					QC 5 - 9	
					QC 5 - 50	
					QC 5 - 30	
					QC 5 - 40	
240	Handfinish - 1-2- Chemical-	1	7/30/19	0.00 0.19	Handfinish - 1 - 1 - B4B	

B4B

pcs

Handfinish - 1 - 2 - B4B

Handfinish - 1 - 3 - B4B

Handfinish - 1 - 4 - B4B

Handfinish - 1 - 5 - B4B

Handfinish - 1 - 6 - B4B

Handfinish - 1 - 7 - B4B

Handfinish - 1 - 8 - B4B

Handfinish - 1 - 9 - B4B

Handfinish - 1 - 10 - B4B

Handfinish - 1 - 11 - B4B

Handfinish - 1 - 12 - B4B

Handfinish - 1 - 13 - B4B

Handfinish - 1 - 14 - B4B

Handfinish - 1 - 15 - B4B

Handfinish - 1 - 16 - B4B

Handfinish - 1 - 17 - B4B

Handfinish - 1 - 18 - B4B

Handfinish - 1 - 19 - B4B

Handfinish - 1 - 20 - B4B

Handfinish - 1 - 21 - B4B

Handfinish - 1 - 22 - B4B

SEP 16 2019

250 Powdercoat - 1 White Gl(A)-
B4B1
pcs

7/30/19

0.00 0.16

Powdercoat - 1 - B4B

Powdercoat - 2 - B4B

Powdercoat - 3 - B4B

Powdercoat - 4 - B4B

START: 1:00 O.U.T. 320° FINISH: 1:30

BX 19-9-16

260 Handfinish - 3-1- WingWalk-
B4B1
pcs

7/30/19

0.00 0.19

Handfinish - 3 - 1 - B4B

Handfinish - 3 - 2 - B4B

Handfinish - 3 - 3 - B4B

Handfinish - 3 - 4 - B4B

Handfinish - 3 - 5 - B4B

1119-9-12

270 QC 3

1
pcs

7/30/19

0.00 0.00

QC 3 - 10

QC 3 - 13

QC 3 - 15

QC 3 - 17

QC 3 - 18

QC 3 - 2

QC 3 - 28

QC 3 - 3

QC 3 - 30

QC 3 - 34

QC 3 - 36

QC 3 - 41

QC 3 - 51

QC 3 - 58

QC 3 - 59

QC 3 - 68

QC 3 - 9

QC 3 - 40

QC 3 - 19

QC 3 - 43

QC 3 - 24

QC 3 - 61

QC 3 - 81

DAS
81
9-89

SEP 18 2019

280 Packaging 1-1 - Pick Kit -
B4B1
pcs

7/30/19

0.00 0.00

Packaging 1 - 1 - B4B

Packaging 1 - 2 - B4B

Packaging 1 - 3 - B4B

Packaging 1 - 4 - B4B

Packaging 1 - 5 - B4B

Packaging 1 - 6 - B4B

Wed 9-18-2019

Rosales, Oscar (041982)

				Packaging 1 - 7 - B4B	
				Packaging 1 - 8 - B4B	
				Packaging 1 - 9 - B4B	
				Packaging 1 - 10 - B4B	
				Packaging 1 - 11 - B4B	
				Packaging 1 - 12 - B4B	
				Packaging 1 - 13 - B4B	
				Packaging 1 - 14 - B4B	
				Packaging 1 - 15 - B4B	
				Packaging 1 - 16 - B4B	
				Packaging 1 - 17 - B4B	
				Packaging 1 - 18 - B4B	
				Packaging 1 - 19 - B4B	
				Packaging 1 - 20 - B4B	
				Packaging 1 - 21 - B4B	
				Packaging 1 - 22 - B4B	
				Packaging 1 - 23 - B4B	
				Packaging 1 - 24 - B4B	
				Packaging 1 - 25 - B4B	
				Packaging 1 - 26 - B4B	
				Packaging 1 - 27 - B4B	
				Packaging 1 - 28 - B4B	
				Packaging 1 - 29 - B4B	
				Packaging 1 - 30 - B4B	
				Packaging 1 - 31 - B4B	
				Packaging 1 - 32 - B4B	
				Packaging 1 - 33 - B4B	
				Packaging 1 - 34 - B4B	
				Packaging 1 - 35 - B4B	
				Packaging 1 - 36 - B4B	
290 QC 4	1 pcs	7/30/19	0.00 0.00	QC 4 - 28	
				QC 4 - 58	
				QC 4 - 69	
				QC 4 - 9	
				QC 4 - 46	
				QC 4 - 68	
				QC 4 - 72	
				QC 4 - 74	
				QC 4 - 75	
300 Packaging 3-1 - Stock - B4B	1 pcs	7/30/19	0.00 0.00	Packaging 3 - 1 - B4B	
				Packaging 3 - 2 - B4B	
				Packaging 3 - 3 - B4B	
				Packaging 3 - 4 - B4B	
				Packaging 3 - 5 - B4B	
				Packaging 3 - 6 - B4B	
				Packaging 3 - 7 - B4B	
				Packaging 3 - 8 - B4B	
				Packaging 3 - 9 - B4B	
				Packaging 3 - 10 - B4B	
				Packaging 3 - 11 - B4B	
				Packaging 3 - 12 - B4B	
				Packaging 3 - 13 - B4B	
				Packaging 3 - 14 - B4B	
				Packaging 3 - 15 - B4B	
				Packaging 3 - 16 - B4B	
				Packaging 3 - 17 - B4B	
				Packaging 3 - 18 - B4B	
				Packaging 3 - 19 - B4B	
				Packaging 3 - 20 - B4B	

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19
9/18/2019

				Packaging 3 - 21 - B4B	
				Packaging 3 - 22 - B4B	
				Packaging 3 - 23 - B4B	
				Packaging 3 - 24 - B4B	
				Packaging 3 - 25 - B4B	
				Packaging 3 - 26 - B4B	
				Packaging 3 - 27 - B4B	
				Packaging 3 - 28 - B4B	
				Packaging 3 - 29 - B4B	
				Packaging 3 - 30 - B4B	
				Packaging 3 - 31 - B4B	
				Packaging 3 - 32 - B4B	
				Packaging 3 - 33 - B4B	
				Packaging 3 - 34 - B4B	
				Packaging 3 - 35 - B4B	
				Packaging 3 - 36 - B4B	
305	DC - 1 - B4B	1	7/30/19	0.00 0.00	DC - 1 - B4B
		pcs			DC - 2 - B4B
310	QC 21 - FG	1	7/30/19	0.00 0.00	QC 21 - FG - 21
		pcs			QC 21 - FG - 70
					QC 21 - SA - 53

NC

DAG
21
9-22 SEP 19 2019
DAG
21
9-22 SEP 19 2019
FG039

Part Op 170 - (Chemical Conversion Coat per QSI005 4.1)
 Descriptions: 180 - (QC7-Inspect Chemical Conversion Coat)
 190 - (Weld per dwg A/R Aluminum rod Batch: 1288732) 1-Rivet Leg Assembly as per Dwg D2351 2-Weld Fwd End Plate per QSI 004 & Dwg D2351 A/RAluminum Rod 1288732-Grind end plate flush.
 220 - (QC10- Inspect visual per QSI004- ground welds)
 230 - (QC5- Inspect part completeness to step on W/O)
 240 - (Chemical Conversion Coat per QSI005 4.1)
 250 - (White Gloss(Ref:4.3.5.1) per QSI005 4.3-Alum) START TIME: _____ OVEN TEMPERATURE: _____
 FINISH TIME: _____
 260 - (Wing Walk as per dwg QSI005 4.4 Batch _____)
 270 - (QC3- Inspect Part Finish)
 280 - (Pick Kit)
 290 - (QC4- 100% Inspect kits for completeness)
 300 - Identify and pack for shipping as per PPP D350-591-121 Location:FG039
 305 - (Document Control) Photocopy bluefile and type labels as per PPP D350-591-121 CHG005
 310 - (QC21- Final Inspection - Work Order Release)

Job BOM

Part / Item	Component Name	Quantity	Operation	Container
D2582	Hi-Skid Step Leg Assembly	1 pcs (1 ea)	190-Large Fab - Steps - 3 - B4B	5210377
D2673-34	End Plate	1 pcs (1 ea)	190-Large Fab - Steps - 3 - B4B	5182722
MS20600-AD4W3	Cherry Rivet	16 Ea (16 ea)	190-Large Fab - Steps - 3 - B4B	5194356
AN3-37A	Bolt	2 Ea (2 ea) ✓	280-Packaging 1-1 - Pick Kit - B4B	5194363 ✓
AN4-13A	Bolt	1 Ea (1 ea) ✓	280-Packaging 1-1 - Pick Kit - B4B	5196190 ✓
AN4-16A	Bolt	2 Ea (2 ea) ✓	280-Packaging 1-1 - Pick Kit - B4B	5196064 ✓
Q2230-1	Mounting Lug	1 pcs (1 ea) ✓	280-Packaging 1-1 - Pick Kit - B4B	5199732 ✓
D2230-3	Mounting Lug	1 pcs (1 ea) ✓	280-Packaging 1-1 - Pick Kit - B4B	5199078 ✓
D2732-030	Rubber Cushion - 3"	2 pcs (2 ea) ✓	280-Packaging 1-1 - Pick Kit - B4B	5205156 ✓
MS21042L3	Nut	2 Ea (2 ea) ✓	280-Packaging 1-1 - Pick Kit - B4B	5204283 ✓
MS21042L4	Nut	3 Ea (3 ea) ✓	280-Packaging 1-1 - Pick Kit - B4B	5211536 ✓
NAS1149D0363J	Washer	4 Ea (4 ea) ✓	280-Packaging 1-1 - Pick Kit - B4B	5201031 ✓
NAS1149D0463J	Washer	6 Ea (6 ea) ✓	280-Packaging 1-1 - Pick Kit - B4B	5192447 ✓

(011982)

Wed 9-18-2019

Oscar

Job Allocations				
Operation	Component Part	Required	Inventory	Allocated
190-Large Fab - Steps - 3 - B4B	D2582	1	3	0
	D2673-34	1	69	0
	MS20600-AD4W3	16	928	0
	AN3-37A	2	83	0
280-Packaging 1-1 - Pick Kit - B4B	AN4-13A	1	1,434	0
	AN4-16A	2	1,143	0
	D2230-1	1	371	0
	D2230-3	1	759	0
	D2732-030	2	488	0
	MS21042L3	2	969	0
	MS21042L4	3	2,946	0
	NAS1149D0363J	4	1,276	0
	NAS1149D0463J	6	4,190	0
Part Specifications				
Specifications could not be found.				

Plex 7/24/19 8:37 AM dart.iacelle.linda



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D350-591-121
Job Sheet 196994



SALE (3)

Part No: D350-591-121

Job Qty: 4 pcs

Part Name: Heli-Access-Step™ LH - High Gear, Short Step, Float Compatible



Part Weight: 0 lbs

Status: New

Priority: Medium

Job Created: 6/26/19

Job Tracking No:

Created By: Kimberley Guerin

Due Date: 7/30/19

Description:

Type: Stock

Note: DWG IIN-D350-591 REV H, D2351-041 REV E IPP Rev:E 02.10.21 Re-format; Incorporated D2351-041 IPP KJ/RF IPP rev. F 06.02.23 added grinding EC

Ship Via:

Bill of Materials

Job Routing

Op No	Operation	Qty	Start Date	Due Date	Standard		Workcenter/Supplier		Sign-off
					Setup Hrs	Run Hrs	Workcenter / Supplier	Lead Time	
110	Large Fab - Steps - 1	4 pcs	7/30/19		0.00	2.72	Large Fab - 1		<i>SLG</i>
							Large Fab - 10		
							Large Fab - 2		
							Large Fab - 3		
							Large Fab - 4		
							Large Fab - 5		
							Large Fab - 6		
							Large Fab - 7		
							Large Fab - 8		
							Large Fab - 9		
							Large Fab - 11 (Various)		
120	Skidtubes - Bend - 2 - B4B	4 pcs	7/30/19		0.38	1.17	Skidtubes - Bend - B4B		<i>JK</i>
122	QC 5	4 pcs	7/30/19		0.00	0.00	QC 5 - 10		
							QC 5 - 12		
							QC 5 - 17		
							QC 5 - 18		
							QC 5 - 19		
							QC 5 - 22	DAS	
							QC 5 - 24	24	
							QC 5 - 3	9.89	
							QC 5 - 43		
							QC 5 - 49		
							QC 5 - 51		
							QC 5 - 58		
							QC 5 - 68		
							QC 5 - 9		
							QC 5 - 50		
							QC 5 - 30		
							QC 5 - 40		
140	Large Fab - Steps - 2 - B4B	4	7/30/19		0.00	2.72	Large Fab - 1 - B4B		

Plex 6/26/19 4:20 PM Dart.Guerin.Kimberley

pcs	4	7/30/19	0.00 0.00	Large Fab - 10 - B4B	
				Large Fab - 2 - B4B	
				Large Fab - 3 - B4B	
				Large Fab - 4 - B4B	
				Large Fab - 5 - B4B	
				Large Fab - 6 - B4B	
				Large Fab - 7 - B4B	22
				Large Fab - 8 - B4B	
				Large Fab - 9 - B4B	
				Large Fab - 11 - B4B (Various)	
				QC 9 - 10	
				QC 9 - 18	DAS
150 QC 9	4 pcs	7/30/19	0.00 0.00	QC 9 - 24	24 JUL 9 3 2019
				QC 9 - 43	9-89 JUL 2 3 2019
				QC 9 - 50	
				QC 9 - 9	
				QC 5 - 10	
				QC 5 - 12	
160 QC 5	4 pcs	7/30/19	0.00 0.00	QC 5 - 17	
				QC 5 - 18	
				QC 5 - 19	
				QC 5 - 22	
				QC 5 - 24	DAS JUL 9 3 2019
				QC 5 - 3	24 JUL 2 3 2019
				QC 5 - 43	9-89
				QC 5 - 49	
				QC 5 - 51	
				QC 5 - 58	
				QC 5 - 68	
				QC 5 - 9	
				QC 5 - 50	
				QC 5 - 30	
				QC 5 - 40	
170 Handfinish - 1-1 Chemical-B4B	4 pcs	7/30/19	0.00 0.74	Handfinish - 1 - 1 - B4B	M 19-7-27
				Handfinish - 1 - 2 - B4B	
				Handfinish - 1 - 3 - B4B	
				Handfinish - 1 - 4 - B4B	
				Handfinish - 1 - 5 - B4B	
				Handfinish - 1 - 6 - B4B	
				Handfinish - 1 - 7 - B4B	
				Handfinish - 1 - 8 - B4B	
				Handfinish - 1 - 9 - B4B	
				Handfinish - 1 - 10 - B4B	
				Handfinish - 1 - 11 - B4B	
				Handfinish - 1 - 12 - B4B	
				Handfinish - 1 - 13 - B4B	
				Handfinish - 1 - 14 - B4B	
				Handfinish - 1 - 15 - B4B	
				Handfinish - 1 - 16 - B4B	
				Handfinish - 1 - 17 - B4B	
				Handfinish - 1 - 18 - B4B	
				Handfinish - 1 - 19 - B4B	
				Handfinish - 1 - 20 - B4B	
				Handfinish - 1 - 21 - B4B	
				Handfinish - 1 - 22 - B4B	
180 QC 7	4 pcs	7/30/19	0.00 0.00	QC 7 - 10	
				QC 7 - 13	
				QC 7 - 14	

				QC 7 - 15	
				QC 7 - 17	
				QC 7 - 18	
				QC 7 - 19	
				QC 7 - 2	
				QC 7 - 28	
				QC 7 - 3	
				QC 7 - 30	
				QC 7 - 34	
				QC 7 - 36	
				QC 7 - 37	
				QC 7 - 41	
				QC 7 - 47	
				QC 7 - 48	
				QC 7 - 51	
				QC 7 - 58	
				QC 7 - 59	
				QC 7 - 60	
				QC 7 - 9	
				QC 7 - 68	
				QC 7 - 50	
				QC 7 - 67	
				QC 7 - 40	
				QC 7 - 24	
				QC 7 - 43	
				QC 7 - 61	
				QC 7 - 81	
190 Large Fab - Steps - 3 - B4B	4 pcs	7/30/19	0.00 2.72	Large Fab - 1 - B4B	
				Large Fab - 10 - B4B	
				Large Fab - 2 - B4B	
				Large Fab - 3 - B4B	
				Large Fab - 4 - B4B	
				Large Fab - 5 - B4B	
				Large Fab - 6 - B4B	
				Large Fab - 7 - B4B	
				Large Fab - 8 - B4B	
				Large Fab - 9 - B4B	
				Large Fab - 11 - B4B (Various)	
220 QC 10	4 pcs	7/30/19	0.00 0.00	QC 10 - 10	
				QC 10 - 18	
				QC 10 - 24	
				QC 10 - 43	
				QC 10 - 50	
				QC 10 - 58	
				QC 10 - 9	
230 QC 5	4 pcs	7/30/19	0.00 0.00	QC 5 - 10	
				QC 5 - 12	
				QC 5 - 17	
				QC 5 - 18	
				QC 5 - 19	
				QC 5 - 22	
				QC 5 - 24	
				QC 5 - 3	
				QC 5 - 43	
				QC 5 - 49	
				QC 5 - 51	
				QC 5 - 58	
				QC 5 - 68	

240 Handfinish - 1-2- Chemical-B4B	4 pcs	7/30/19	0.00 0.74	QC 5 - 9	
				QC 5 - 50	
				QC 5 - 30	
				QC 5 - 40	
				Handfinish - 1 - 1 - B4B	
				Handfinish - 1 - 2 - B4B	
				Handfinish - 1 - 3 - B4B	
				Handfinish - 1 - 4 - B4B	
				Handfinish - 1 - 5 - B4B	
				Handfinish - 1 - 6 - B4B	
				Handfinish - 1 - 7 - B4B	
				Handfinish - 1 - 8 - B4B	
				Handfinish - 1 - 9 - B4B	
				Handfinish - 1 - 10 - B4B	
				Handfinish - 1 - 11 - B4B	
				Handfinish - 1 - 12 - B4B	
				Handfinish - 1 - 13 - B4B	
				Handfinish - 1 - 14 - B4B	
				Handfinish - 1 - 15 - B4B	
				Handfinish - 1 - 16 - B4B	
				Handfinish - 1 - 17 - B4B	
				Handfinish - 1 - 18 - B4B	
				Handfinish - 1 - 19 - B4B	
				Handfinish - 1 - 20 - B4B	
				Handfinish - 1 - 21 - B4B	
				Handfinish - 1 - 22 - B4B	
250 Powdercoat - 1 White GI(A)-B4B	4 pcs	7/30/19	0.00 0.65	Powdercoat - 1 - B4B	
				Powdercoat - 2 - B4B	
				Powdercoat - 3 - B4B	
				Powdercoat - 4 - B4B	
260 Handfinish - 3-1- WingWalk-B4B	4 pcs	7/30/19	0.00 0.74	Handfinish - 3 - 1 - B4B	
				Handfinish - 3 - 2 - B4B	
				Handfinish - 3 - 3 - B4B	
				Handfinish - 3 - 4 - B4B	
				Handfinish - 3 - 5 - B4B	
270 QC 3	4 pcs	7/30/19	0.00 0.00	QC 3 - 10	
				QC 3 - 13	
				QC 3 - 15	
				QC 3 - 17	
				QC 3 - 18	
				QC 3 - 2	
				QC 3 - 28	
				QC 3 - 3	
				QC 3 - 30	
				QC 3 - 34	
				QC 3 - 36	
				QC 3 - 41	
				QC 3 - 51	
				QC 3 - 58	
				QC 3 - 59	
				QC 3 - 68	
				QC 3 - 9	
				QC 3 - 40	
				QC 3 - 19	
				QC 3 - 43	
				QC 3 - 24	
				QC 3 - 61	
				QC 3 - 81	
280 Packaging 1-1 - Pick Kit -	4	7/30/19	0.00 0.00	Packaging 1 - 1 - B4B	

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B4B	pcs				Packaging 1 - 2 - B4B	
					Packaging 1 - 3 - B4B	
					Packaging 1 - 4 - B4B	
					Packaging 1 - 5 - B4B	
					Packaging 1 - 6 - B4B	
					Packaging 1 - 7 - B4B	
					Packaging 1 - 8 - B4B	
					Packaging 1 - 9 - B4B	
					Packaging 1 - 10 - B4B	
					Packaging 1 - 11 - B4B	
					Packaging 1 - 12 - B4B	
					Packaging 1 - 13 - B4B	
					Packaging 1 - 14 - B4B	
					Packaging 1 - 15 - B4B	
					Packaging 1 - 16 - B4B	
					Packaging 1 - 17 - B4B	
					Packaging 1 - 18 - B4B	
					Packaging 1 - 19 - B4B	
					Packaging 1 - 20 - B4B	
					Packaging 1 - 21 - B4B	
					Packaging 1 - 22 - B4B	
					Packaging 1 - 23 - B4B	
					Packaging 1 - 24 - B4B	
					Packaging 1 - 25 - B4B	
					Packaging 1 - 26 - B4B	
					Packaging 1 - 27 - B4B	
					Packaging 1 - 28 - B4B	
					Packaging 1 - 29 - B4B	
					Packaging 1 - 30 - B4B	
					Packaging 1 - 31 - B4B	
					Packaging 1 - 32 - B4B	
					Packaging 1 - 33 - B4B	
					Packaging 1 - 34 - B4B	
					Packaging 1 - 35 - B4B	
					Packaging 1 - 36 - B4B	
290 QC 4	4 pcs	7/30/19	0.00	0.00	QC 4 - 28	
					QC 4 - 58	
					QC 4 - 69	
					QC 4 - 9	
					QC 4 - 46	
					QC 4 - 68	
					QC 4 - 72	
					QC 4 - 74	
					QC 4 - 75	
300 Packaging 3-1 - Stock - B4B	4 pcs	7/30/19	0.00	0.00	Packaging 3 - 1 - B4B	
					Packaging 3 - 2 - B4B	
					Packaging 3 - 3 - B4B	
					Packaging 3 - 4 - B4B	
					Packaging 3 - 5 - B4B	
					Packaging 3 - 6 - B4B	
					Packaging 3 - 7 - B4B	
					Packaging 3 - 8 - B4B	
					Packaging 3 - 9 - B4B	
					Packaging 3 - 10 - B4B	
					Packaging 3 - 11 - B4B	
					Packaging 3 - 12 - B4B	
					Packaging 3 - 13 - B4B	
					Packaging 3 - 14 - B4B	
					Packaging 3 - 15 - B4B	

				Packaging 3 - 16 - B4B	
				Packaging 3 - 17 - B4B	
				Packaging 3 - 18 - B4B	
				Packaging 3 - 19 - B4B	
				Packaging 3 - 20 - B4B	
				Packaging 3 - 21 - B4B	
				Packaging 3 - 22 - B4B	
				Packaging 3 - 23 - B4B	
				Packaging 3 - 24 - B4B	
				Packaging 3 - 25 - B4B	
				Packaging 3 - 26 - B4B	
				Packaging 3 - 27 - B4B	
				Packaging 3 - 28 - B4B	
				Packaging 3 - 29 - B4B	
				Packaging 3 - 30 - B4B	
				Packaging 3 - 31 - B4B	
				Packaging 3 - 32 - B4B	
				Packaging 3 - 33 - B4B	
				Packaging 3 - 34 - B4B	
				Packaging 3 - 35 - B4B	
				Packaging 3 - 36 - B4B	
305 DC - 1 - B4B	4	7/30/19	0.00 0.00	DC - 1 - B4B	
	pcs			DC - 2 - B4B	
310 QC 21 - FG	4	7/30/19	0.00 0.00	QC 21 - FG - 21	
	pcs			QC 21 - FG - 70	
				QC 21 - SA - 53	

Part Op 110 - (Fabricate per Drwg) 1-Cut D2244-116 extrusion to 55.32" long as per Dwg D2351 2- Drill holes as per dwg using Descriptions: DT8230.

120 - (CNC Delta 100 Bender) Bend as per Dwg D2351-041 using CNC Bender 1 and Folio FT011. Use Bend Program D2351-041. Use DT8033 jig to make sure bend is good and fits the jig.

122 - (QC5- Inspect part completeness to step on W/O)

140 - (Weld per dwg A/R Aluminum rod Batch: _____) 1-Bevel Fwd and Aft end for welding 2-Weld Aft End Bracket per QSI 004 & Dwg D2351 using Welding Jig DT8033 A/RAluminum Rod _____ 3-Do not Grind Flush

150 - (QC9- Inspect visual per QSI004- Fusion Welds)

160 - (QC5- Inspect part completeness to step on W/O)

170 - (Chemical Conversion Coat per QSI005 4.1)

180 - (QC7-Inspect Chemical Conversion Coat)

190 - (Weld per dwg A/R Aluminum rod Batch: _____) 1-Rivet Leg Assembly as per Dwg D2351 2-Weld Fwd End Plate per QSI 004 & Dwg D2351 A/RAluminum Rod _____ 3-Grind end plate flush.

220 - (QC10- Inspect visual per QSI004- ground welds)

230 - (QC5- Inspect part completeness to step on W/O)

240 - (Chemical Conversion Coat per QSI005 4.1)

250 - (White Gloss(Ref:4.3.5.1) per QSI005 4.3-Alum) START TIME: _____ OVEN TEMPERATURE: _____ FINISH TIME: _____

260 - (Wing Walk as per dwg QSI005 4.4 Batch _____)

270 - (QC3- Inspect Part Finish)

280 - (Pick Kit)

290 - (QC4- 100% Inspect kits for completeness)

300 - Identify and pack for shipping as per PPP D350-591-121 Location:FG039

305 - (Document Control) Photocopy bluefile and type labels as per PPP D350-591-121 CHG005

310 - (QC21- Final Inspection - Work Order Release)

Job BOM

Part / Item	Component Name	Quantity	Operation	Container
D2244-116	Step Extrusion	2 pcs (.5 ea)	110-Large Fab - Steps - 1	5164553
D2850-1	End Bracket	4 pcs (1 ea)	140-Large Fab - Steps - 2 - B4B	5199373
D2582	Hi-Skid Step Leg Assembly	4 pcs (1 ea)	190-Large Fab - Steps - 3 - B4B	5176262
D2673-34	End Plate	4 pcs (1 ea)	190-Large Fab - Steps - 3 - B4B	5161432
MS20600-AD4W3	Cherry Rivet	64 Ea (16 ea)	190-Large Fab - Steps - 3 - B4B	5194356
AN3-37A	Bolt	8 Ea (2 ea)	280-Packaging 1-1 - Pick Kit - B4B	
AN4-13A	Bolt	4 Ea (1 ea)	280-Packaging 1-1 - Pick Kit - B4B	
AN4-16A	Bolt	8 Ea (2 ea)	280-Packaging 1-1 - Pick Kit - B4B	
D2230-1	Mounting Lug	4 pcs (1 ea)	280-Packaging 1-1 - Pick Kit - B4B	
D2230-3	Mounting Lug	4 pcs (1 ea)	280-Packaging 1-1 - Pick Kit - B4B	
D2732-030	Rubber Cushion - 3"	8 pcs (2 ea)	280-Packaging 1-1 - Pick Kit - B4B	
MS21042L3	Nut	8 Ea (2 ea)	280-Packaging 1-1 - Pick Kit - B4B	
MS21042L4	Nut	12 Ea (3 ea)	280-Packaging 1-1 - Pick Kit - B4B	
NAS1149D0363J	Washer	16 Ea (4 ea)	280-Packaging 1-1 - Pick Kit - B4B	
NAS1149D0463J	Washer	24 Ea (6 ea)	280-Packaging 1-1 - Pick Kit - B4B	

Job Allocations

Operation	Component Part	Required	Inventory	Allocated
110-Large Fab - Steps - 1	D2244-116	2	8	0
140-Large Fab - Steps - 2 - B4B	D2850-1	4	2	0
190-Large Fab - Steps - 3 - B4B	D2582	4	3	0
	D2673-34	4	69	0
	MS20600-AD4W3	64	340	0
280-Packaging 1-1 - Pick Kit - B4B	AN3-37A	8	57	0
	AN4-13A	4	430	0
	AN4-16A	8	671	0
	D2230-1	4	226	0
	D2230-3	4	815	0
	D2732-030	8	524	0
	MS21042L3	8	1,144	0
	MS21042L4	12	2,404	0
	NAS1149D0363J	16	1,569	0
	NAS1149D0463J	24	3,168	0

Part Specifications

Specifications could not be found.

Plex 6/26/19 4:20 PM Dart.Guerin.Kimberley

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5.0 PARTS LIST

Qty -117A	Qty -119	Qty -133	Part Number	Description
X			D350-591-117A	<i>Heli-Access-Step</i> ™, Pre-Flight Step
	X		D350-591-119	<i>Heli-Access-Step</i> ™, Long Step – Low Skid
		X	D350-591-133	<i>Heli-Access-Step</i> ™, Aft Maintenance Step
	1		D2355	STEP ASSEMBLY (LOW-LONG)
		1	D2946-041	STEP ASSEMBLY (MAINTENANCE)
2	2		D2171	CLAMP
2	2		D2182B035	CUSHION
		4	D2230-1	MOUNTING LUG
		4	D2230-3	MOUNTING LUG
4	4		D2274	RADIUS BLOCK
1			D2362-041	SUPPORT BRACKET
	1		D2362-3	SUPPORT BRACKET
		1	D2945	MOUNTING PLATE
1	1		D3595-200-300	CUSHION
		8	D2732-030	CUSHION
	2		AN3-37A	BOLT
		2	AN4-7A	BOLT
		4	AN4-11A	BOLT
		8	AN4-16A	BOLT
	4		AN4-21A	BOLT
4	1		AN4-22A	BOLT
	4		NAS1149D0363J	WASHER (AN960JD10)
4	6	14	NAS1149D0463J	WASHER (AN960JD416)
	2		MS21042L3	NUT
4	5	14	MS21042L4	NUT

Qty -121	Qty -122	Qty -123	Qty -124	Part Number	Description
X				D350-591-121	<i>Heli-Access-Step</i> ™, Short Step – High Skid, LH
	X			D350-591-122	<i>Heli-Access-Step</i> ™, Short Step – High Skid, RH
		X		D350-591-123	<i>Heli-Access-Step</i> ™, Short Step – Low Skid, LH
			X	D350-591-124	<i>Heli-Access-Step</i> ™, Short Step – Low Skid, RH
1				D2351-041	STEP ASSEMBLY (HIGH-SHORT, LH)
	1			D2351-042	STEP ASSEMBLY (HIGH-SHORT, RH)
		1		D2356-041	STEP ASSEMBLY (LOW-SHORT, LH)
			1	D2356-042	STEP ASSEMBLY (LOW-SHORT, RH)
1	1	1	1	D2230-1	MOUNTING LUG
1	1	1	1	D2230-3	MOUNTING LUG
2	2	2	2	D2732-030	CUSHION
2	2	2	2	AN3-37A	BOLT
1	1	1	1	AN4-13A	BOLT
2	2	2	2	AN4-16A	BOLT
4	4	4	4	NAS1149D0363J	WASHER (AN960JD10)
6	6	6	6	NAS1149D0463J	WASHER (AN960JD416)
2	2	2	2	MS21042L3	NUT
3	3	3	3	MS21042L4	NUT

Change Record

Part Number: D350-591-121

PAGE 1 OF 1

Description: HELI-ACCESS STEP, HIGH SKID, SHORT STEP, LH

[illegible]